

Work Order ID 66243

Tuesday, February 08, 2011 8:57:07 AM

Page 1

Item ID: DSI 9448-011

Accept

Revision ID:

Item Name: Hinge Upgrade

Start Date: 2/7/2011 Start Qty: 1.00

Required Date: 2/8/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

Photocopy bluefile and create labels per PPP DSI 9448-011

0.00

110

Pick Kit

0.00



Packaging

Packaging

Memo

QC 5 100% Inspect kits for completeness

0.00

120



QC

Quality Control

Memo

0.00

111

WF

Weld as per drawing DSI 9448 Rev. I

112

SF

Assemble as per drawing DSI 9448 Rev. I

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-39 TEL 1-613-632-5200	
P-N	D206-540-013	CHG	CHG005		
DESC	Heli-Utility-Basket	STC	SH94-5		
LOT	B40843	STC	SR00386NY		
MODEL	206A/B	STC			
MADE IN CANADA				02724-1	

NAT

EP 11/02/10

EP 11-02-10

EP 11/02/10

Work Order ID 66243

Tuesday, February 08, 2011 8:57:07 AM

Page 2

Item ID: DSI 9448-011

Accept

Revision ID:

Item Name: Hinge Upgrade

Start Date: 2/7/2011 Start Qty: 1.00

Required Date: 2/8/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI 9448-011
Location: _____

*do 103706
customer plus*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/03
U 4034

Picklist Print

Tuesday, February 08, 2011 8:57:04 AM

Page 1

Work Order ID: 66243

Parent Item: DSI 9448-011

Parent Item Name: Hinge Upgrade



Start Date: 2/7/2011

Required Date: 2/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3748-1 Hinge Half		Manufactured	No			110	Each	7.0000	3	3			
<div> <div>Location</div> <div>WA</div> <div>57151</div> </div> <div> <div>Loc Qty</div> <div>7</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3749-1 Hinge Half		Manufactured	No			110	Each	12.0000	3	3			
<div> <div>Location</div> <div>WA</div> <div>57748</div> </div> <div> <div>Loc Qty</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3723-1 Bushing		Manufactured	No			110	Each	10.0000	6	6			
<div> <div>Location</div> <div>ST086</div> <div>57543</div> </div> <div> <div>Loc Qty</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
AN4-20A Bolt		Purchased	No			110	Each	452.0000	3	3			
<div> <div>Location</div> <div>ST359</div> <div>104016</div> <div>115936</div> <div>116419</div> </div> <div> <div>Loc Qty</div> <div>452</div> <div>52</div> <div>200</div> <div>200</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													

Cpl 11.02.10

(3)

Cpl 11.02.10

(3)

N/A

N/A

EFS 11/02/10

3

Picklist Print

Tuesday, February 08, 2011 8:57:04 AM

Page 2

Work Order ID: 66243

Parent Item: DSI 9448-011

Parent Item Name: Hinge Upgrade

Start Date: 2/7/2011

Required Date: 2/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-22A

Purchased

No

110

Each

193.0000

1

1



Bolt

Location

Loc Qty

Loc Code

ST359

193

111965

2

114523

41

114784

100

116419

50



EF 11/02/10

AN4-24A

Purchased

No

110

Each

21.0000

1

1



Bolt

Location

Loc Qty

Loc Code

ST359

20

115835

20

ST360

1

112641

1



EF 11/02/10

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

8

8



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6



1116304

EF 11/02/10

AN970-4

Purchased

No

110

Each

67.0000

4

4



Washer

Location

Loc Qty

Loc Code

ST344

67

115936

67



EF 11/02/10

Tuesday, February 08, 2011 8:57:04 AM

Shop Packet Print

Page 2

Picklist Print

Tuesday, February 08, 2011 8:57:04 AM

Page 3

Work Order ID: 66243

Parent Item: DSI 9448-011

Parent Item Name: Hinge Upgrade



Start Date: 2/7/2011

Required Date: 2/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

5,616.000

5

5



Nut



EP 11/02/10

Location

Loc Qty

Loc Code

ST300

5616

1123143

2

115589

10

115621

21

116188

3500

116548

83

116823

2000

5

NAS43DD4-46N

Purchased

No

110

Each

23.0000

3

3



SPACER



EP 11/02/10

Location

Loc Qty

Loc Code

ST279

23

111886

23

3

D206-540-013CM

40843

1 x

✓ 11-03-07

Tuesday, February 08, 2011 8:57:04 AM

Shop Packet Print

Page 3

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-540 REV. I

REF CANADIAN STC: SH94-5

REF FAA STC: SR00386NY

REF GERMAN STC: LBA RC 1124

THIS DART SERVICE INSTRUCTION PROVIDES GUIDELINES TO REPLACE THE EXISTING HINGE PLATES WELDED ON THE BASKET BASE AND LID OF D206-540-011/-013 HELI-UTILITY-BASKET AT CHG 004/CHG 005 RESPECTIVELY WITH D3748-1 AND D3749-1 HINGE HALVES TO ELIMINATE POSSIBLE INTERFERENCE BETWEEN THE BASKET INSTALLATION AND THE CABIN DOOR.

REPLACEMENT PROCEDURE:

- 1) REMOVE PROP ARM FROM LID AND SEPERATE LID FROM BASE.
- 2) TRIM HINGE PLATES FLUSH TO LID/BASE FRAME AS SHOWN IN FIGURE 1. DEBURR.
- 3) REMOVE PAINT IN AREAS WHERE THE NEW D3748-1 (BASE) AND D3749-1 (LID) HINGE HALVES WILL BE WELDED. REFER TO VIEWS A-A AND B-B.
- 4) LOCATE QTY(3) D3748-1 ON BASE AS SHOWN IN VIEW A-A AND TIG WELD PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD.
- 5) POSITION AND CENTER LID ON BASE. SHIM LID BY 0.200". REFER TO VIEW B-B.
- 6) LOCATE QTY(3) D3749-1 ON LID AS FOLLOWS: CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON BASKET BASE ASSEMBLY AND TIG WELD PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD. REFER TO VIEW B-B.
- 7) TRANSFER DRILL Ø0.261" HOLE FROM D3748-1 TO D3749-1. DEBURR. REFER TO VIEW D-D.
- 8) TOUCH UP PAINT/AFFECTED REPAIRED AREAS ON BOTH LID AND BASE WITH ONE COAT OF MIL-P-85582 OR MIL-P-23377 PRIMER AND 2-3 COATS OF MIL-C-85285 POLYURETHANE PAINT TO MATCH ORIGINAL FINISH.
- 9) INSTALL LID ON BASE IN ACCORDANCE WITH FIGURE 2.
- 10) REFASTEN PROP ARM TO LID.

PARTS LIST:

Qty -011	Part No.	Description
X	DSI 9448-011	HINGE UPGRADE KIT
3	D3748-1	HINGE HALF
3	D3749-3	HINGE HALF
6	D3723-1	BUSHING
3	AN4-20A	BOLT
1	AN4-22A	BOLT
1	AN4-24A	BOLT
8	AN960JD416	WASHER
4	AN970-4	WASHER
5	MS21042L4	NUT (OR MS21042-4)
3	NAS43DD4-46	SPACER

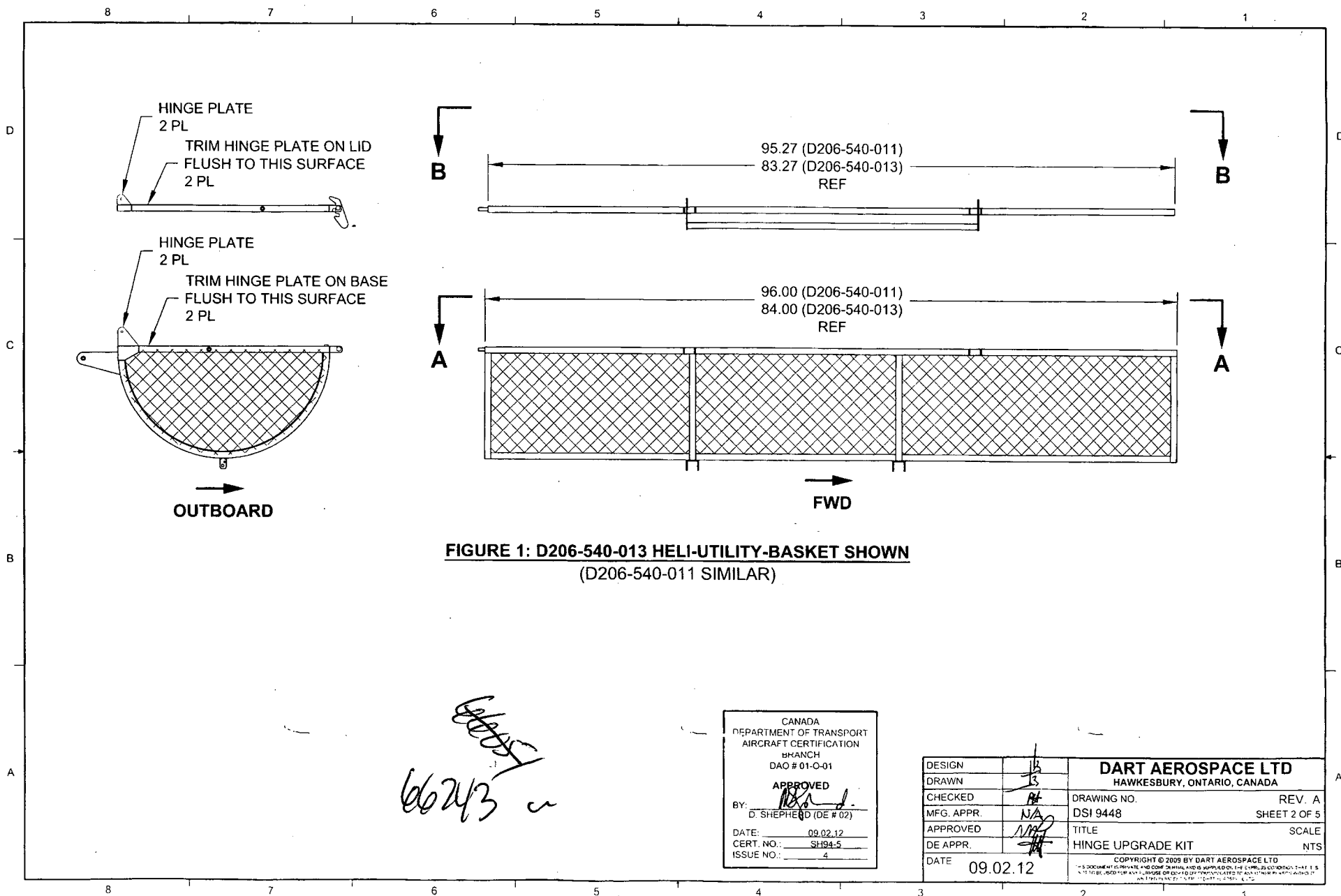
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 09.02.12
CERT. NO.: SH94-5
ISSUE NO.: 4

A	NEW ISSUE	MB	09.02.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>[Signature]</u>	DART AEROSPACE LTD	
DRAWN	<u>[Signature]</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>N/A</u>	DSI 9448	SHEET 1 OF 5
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	HINGE UPGRADE KIT	NTS
DATE	09.02.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



66243

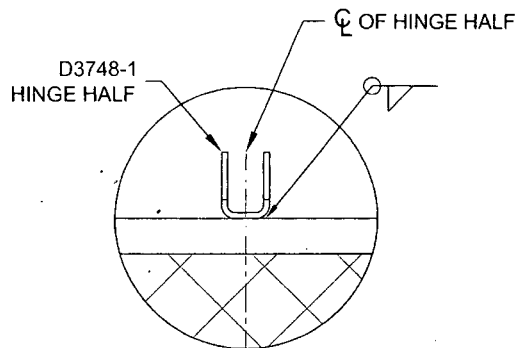
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

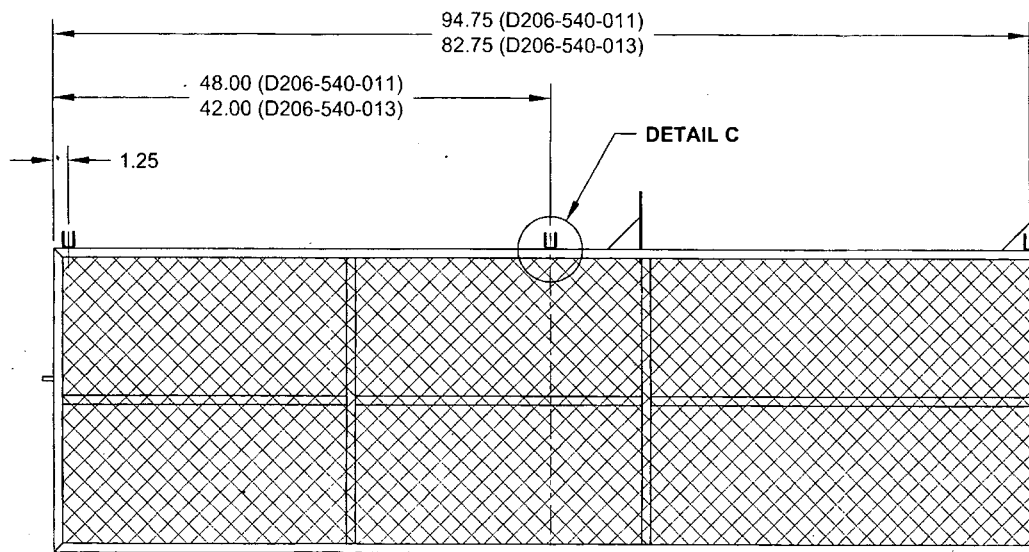
DATE: 09.02.12
CERT. NO.: SH94-5
ISSUE NO.: 4

DESIGN	15	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	13	
CHECKED	14	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9448 SHEET 2 OF 5
APPROVED	11/12	TITLE SCALE
DE APPR.	11/12	HINGE UPGRADE KIT NTS
DATE	09.02.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REPRODUCTION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.



DETAIL C
3 PL, SCALE 4X



→
FWD

VIEW A-A: LOCATION OF HINGE HALVES ON BASE

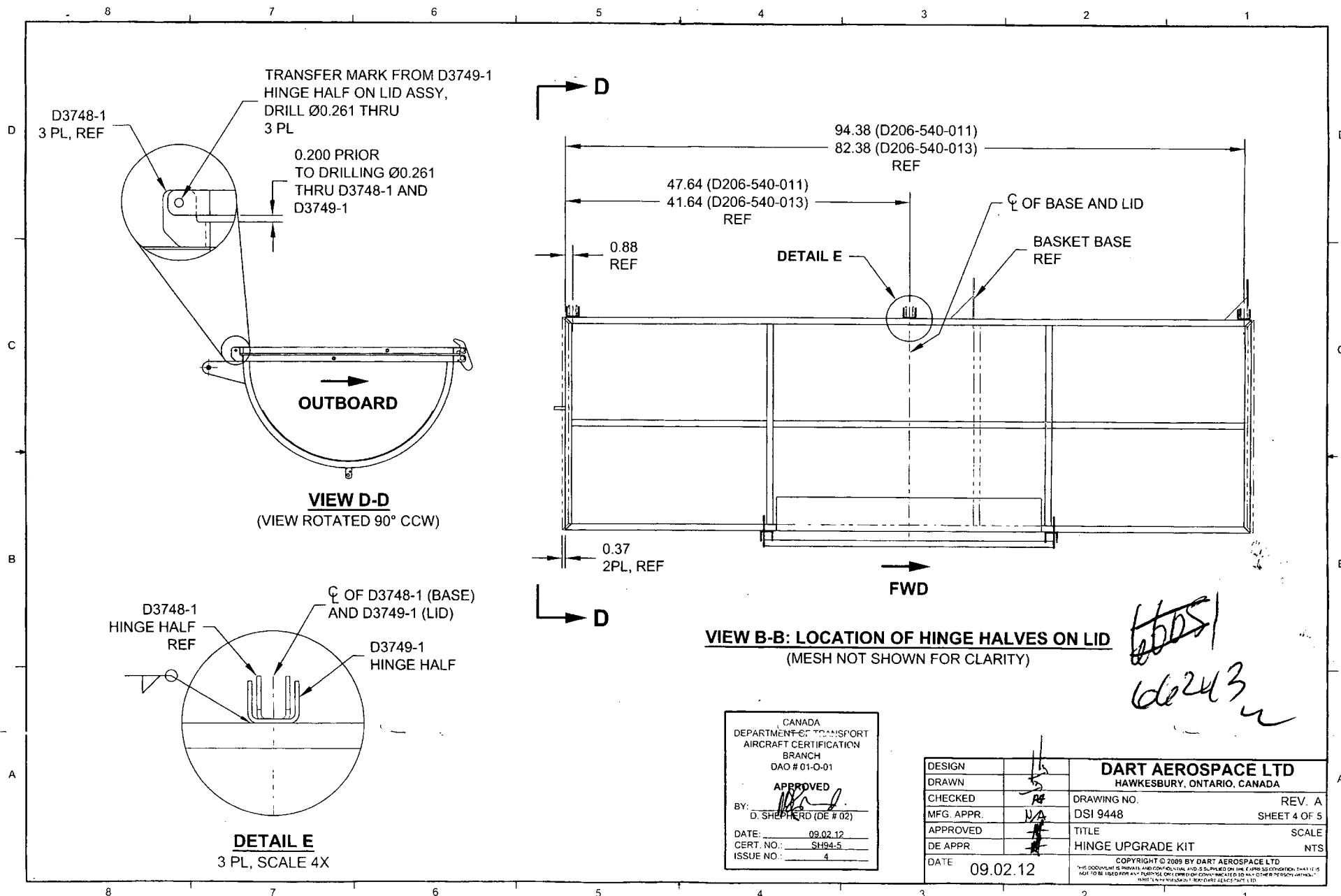
66051
66243

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.02.12
CERT. NO.: SH94-5
ISSUE NO.: 4

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9448	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HINGE UPGRADE KIT	NTS
DATE	09.02.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD	



AN4-22A BOLT
AN960JD416 WASHER
AN970-4 WASHER, 2X
MS21042L4 NUT

BASKET LID
ASSEMBLY

AN4-24A BOLT
AN960JD416 WASHER
AN970-4 WASHER, 2X
MS21042L4 NUT

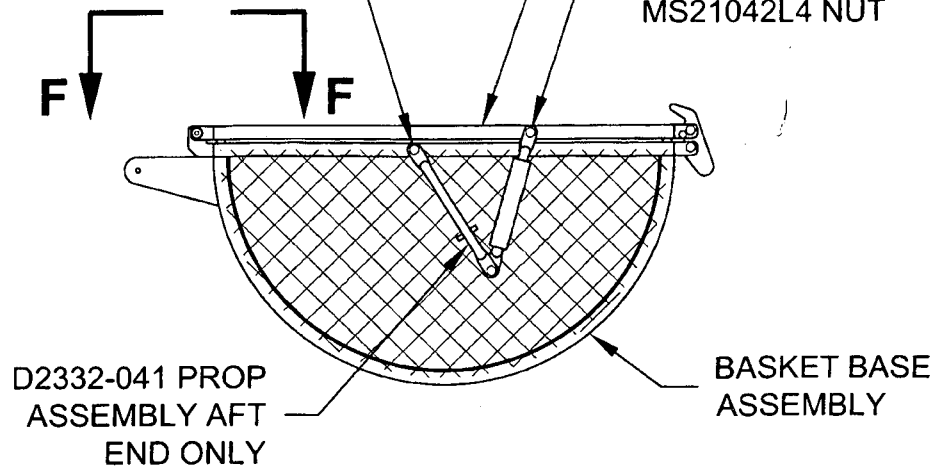
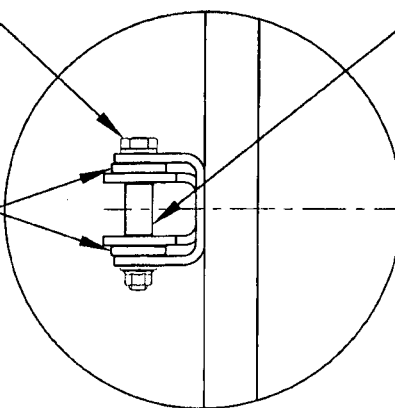


FIGURE 2: INSTALLATION OF LID ON BASE

AN4-20A BOLT
AN960JD416 WASHER
AN960JD416 WASHER
MS21042L4 NUT
3 PL

NAS43DD4-46
SPACER

D3723-1
BUSHING



VIEW F-F
3 PL, SCALE 4X

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.02.12
CERT. NO.: SH94-5
ISSUE NO.: 4

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.: DSI 9448	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HINGE UPGRADE KIT	NTS
DATE	09.02.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

[Handwritten signature]
66243
✓

FOR RE ASSY OF BASKET

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
	4	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD <i>B46850</i>
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY <i>B62950</i>
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT <i>B65094</i>
2	2	D2535	SPRING <i>B64280</i>
2	2	D2537	BUSHING <i>B64064</i>
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
1		D2749-5	STRUT
1	1	D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER <i>B46064</i>
4	4	D3396-3	SPACER
6	6	D3723-1	BUSHING <i>B5754.3(4x) B66495(2x)</i>
2	2	AN3-16A	BOLT <i>M114752</i>
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
3	3	AN4-20A	BOLT <i>M104016</i>
2	2	AN4-21A	BOLT
2	1	AN4-22A	BOLT <i>M114523</i>
6	6	AN5-17A	BOLT <i>M116003</i>
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
20	27	AN960JD416	WASHER <i>M116304</i>
6	6	AN960JD516	WASHER <i>M116540</i>
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER <i>M115936</i>
4	4	MS20600AD4W3	RIVET <i>M111636</i>
2	2	MS21042L3	NUT (OR MS21042-3) <i>M115835</i>
9	9	MS21042L4	NUT (OR MS21042-4) <i>M116188</i>
6	6	MS21042L5	NUT (OR MS21042-5) <i>M115594</i>
	1	MS27039-4-11	SCREW
3	3	NAS43DD4-46	SPACER <i>M111886</i>

*NOTE: Placard D2259 to be installed in cockpit near the airspeed indicator.

AN960JD416 M110153(2x)
AN960JD416 M110153(2x)
M11.02.16

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	3		
CHECKED	HA	DRAWING NO.	REV. J
MFG. APPR.	NA	D206-540	SHEET 2 OF 8
APPROVED	AM	TITLE	SCALE
DE APPR.	HA	UTILITY BASKET INSTALLATION	NTS
DATE	09.02.09	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

66249

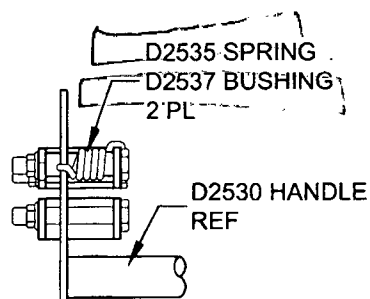
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

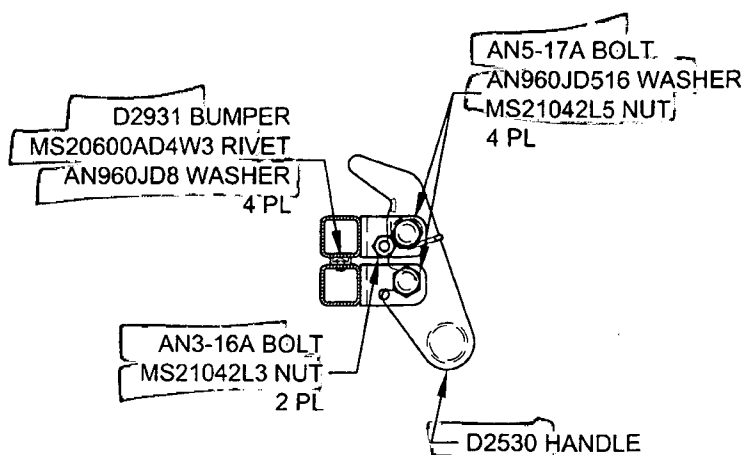
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

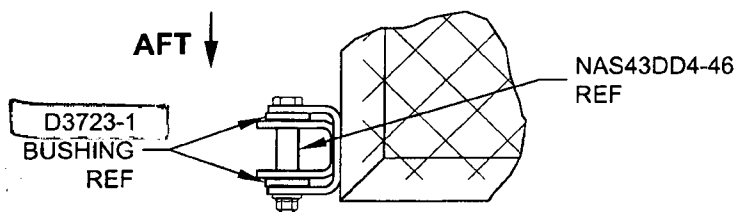
NOTE: Date & initial all entries



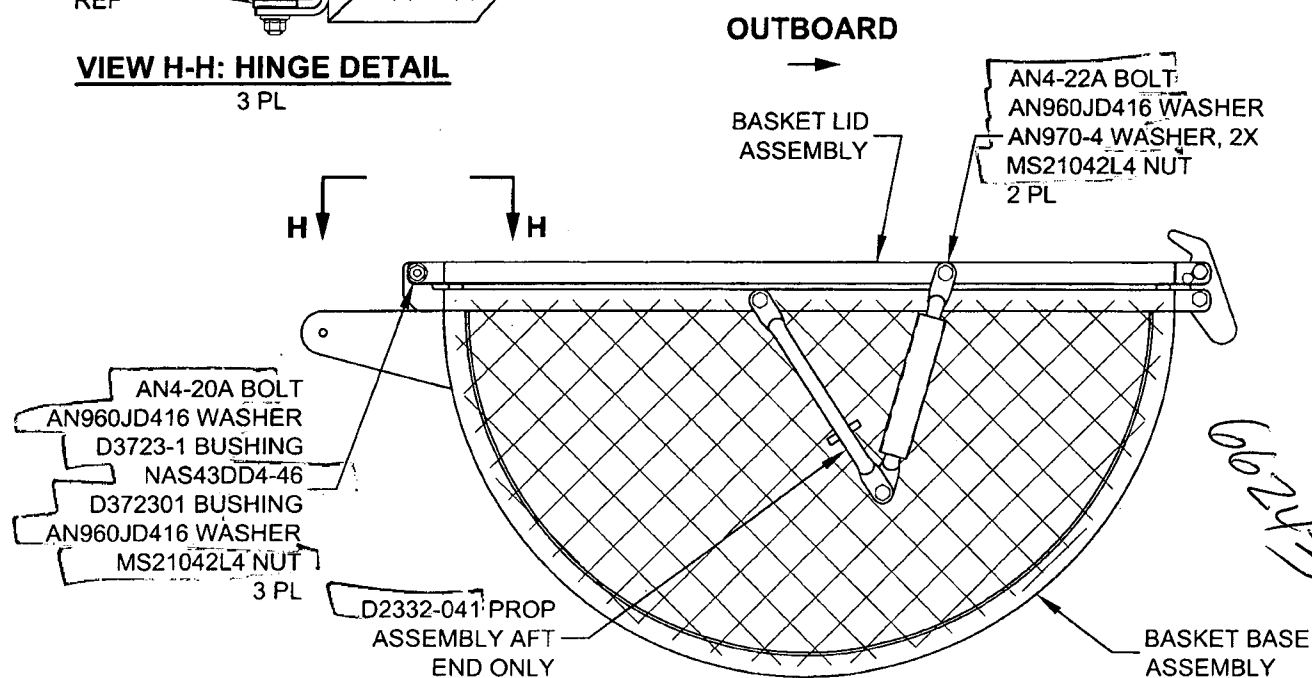
SPRING DETAIL



LATCH DETAIL



VIEW H-H: HINGE DETAIL
3 PL



PROP ARM & HINGE DETAIL
END VIEW, LOOKING FWD

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D206-540	REV. J
MFG. APPR.	N/A		SHEET 8 OF 8
APPROVED	MM	TITLE UTILITY BASKET INSTALLATION	SCALE NTS
DE APPR.	SH		
DATE	09.02.09	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries